

# Work Order ID 147190

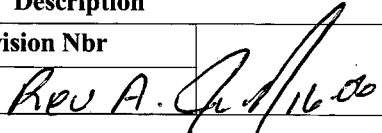
\*147190\*

Page 1

Item ID: D5381-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: ~~PRELIM~~ Stop \*NS2\*  
 Item Name: Window Bushing  
 Start Date: 06/07/2016 Start Qty: 30.00 \*30\* Cust Item ID:  
 Required Date: 06/08/2016 Req'd Qty: 30.00 \*30\* Customer:  
 Reference:

Approvals: Process Plan:  Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr                                                                             |
|----------|------------------------------------------------------------------------------------------|
| D5381    | Rev A.  |

|     |                          |      |  |  |  |  |  |  |     |
|-----|--------------------------|------|--|--|--|--|--|--|-----|
| 100 | Hardinge CNC LATHE SMALL | 0.01 |  |  |  |  |  |  | DAS |
|-----|--------------------------|------|--|--|--|--|--|--|-----|

\*100\*

Hardinge

Hardinge CNC Lathe Small

Memo

1-TURN AS PER FOLIO ~~24030~~ & DWG D5381 ,

FOLIO REV: AA

DWG REV: A.

2-DEBURR AS REQUIRED

|     |                                         |      |  |  |  |  |  |  |     |
|-----|-----------------------------------------|------|--|--|--|--|--|--|-----|
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 |  |  |  |  |  |  | DAS |
|-----|-----------------------------------------|------|--|--|--|--|--|--|-----|

\*110\*

QC

Quality Control

Memo

0.05

30 0 DAS  
49  
9-89  
16/06/08

30 0 DAS  
49  
9-89  
16/06/08

# Work Order ID 147190

Tuesday, June 07, 2016 8:14:37 AM

**\*147190\***

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Item ID: D5381-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: PRELIM Stop **\*NS2\***  
Item Name: Window Bushing  
Start Date: 06/07/2016 Start Qty: 30.00 **\*30\*** Cust Item ID:  
Required Date: 06/08/2016 Req'd Qty: 30.00 **\*30\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID                | Operation<br>Description                                       | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|-----------------------------------------------|----------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120<br><b>*120*</b><br>QC<br>Quality Control  | QC8- Inspect parts - second check<br><br>Memo                  | 0.00<br><br>0.10     |         |        |              | 30            | 0             |                  | Jun 16. 06.08  |
| 130<br><b>*130*</b><br>Packaging<br>Packaging | Identify as per dwg & Stock Location: <u>51/66</u><br><br>Memo | 0.00<br><br>0.05     |         |        |              | 29            | 51            |                  | JUN 09 2016    |
| 140<br><b>*140*</b><br>QC<br>Quality Control  | QC21- Final Inspection - Work Order Release<br><br>Memo        | 0.00<br><br>0.50     |         |        |              | MLJ           |               |                  | JUN 22 2016    |
|                                               |                                                                |                      |         |        |              | MLJ           |               |                  | JUN 09 2016    |

# Picklist Print

Tuesday, June 07, 2016 8:14:36 AM

Page 1

Work Order ID: 147190

**\*147190\***

Parent Item: D5381-1

**\*D5381-1\***

Parent Item Name: Window Bushing

Start Date: 06/07/2016

Required Date: 06/08/2016

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A NEW ISSUE 16.06.07 JLM VERIFIED BY:DD

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M303R0.750                      |                        | Purchased     |             | No                  |                  |                 | f                  | 41.4249        |             | 1.294737     |               |                |        |

**\*M303R0 750\***

303 Round Bar 0.750

**\*\***

Location

Loc Qty

Loc Code

MAT028

41.424921

m133699

1.264921

m134677

24.84

m134776

15.32

DAS  
**49**  
9-89

16/08/07



$\phi 0.313^{+0.000}_{-0.005}$

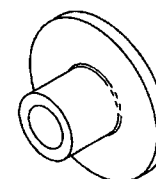
$\phi 0.200$

$\phi 0.75^{+0.00}_{-0.01}$

$0.282^{+0.005}_{-0.000}$

0.060

MINIMUM TOOLING RAD



# **D5381-1 WINDOW BUSHING**

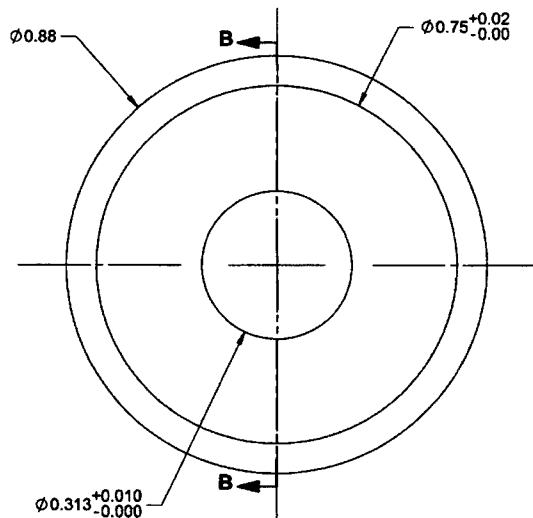
## **NOTES:**

- 1) MATERIAL: 303 SS ROUND BAR PER ASTM A582, REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: <0.01 lbs

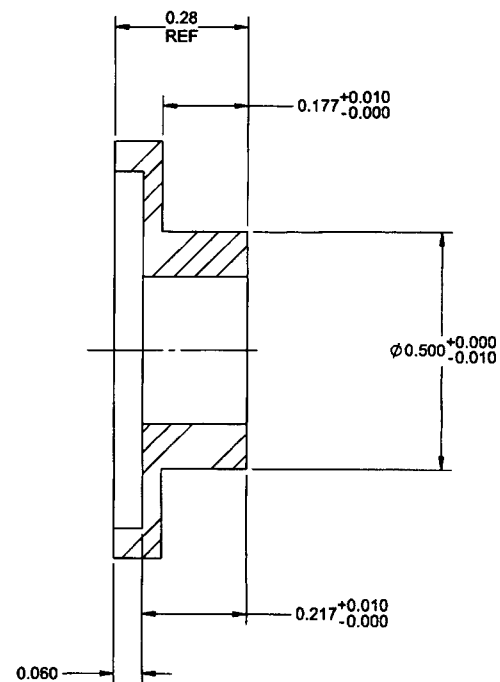
**RELEASED**  
2016-06-08  
ECN 16-576

APPROVED

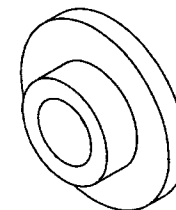
|            |             |                                                                                                                                                                                                                                                                                         |              |
|------------|-------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| A          | NEW ISSUE   | DB                                                                                                                                                                                                                                                                                      | 16.05.13     |
| REV.       | DESCRIPTION | BY                                                                                                                                                                                                                                                                                      | DATE         |
| DESIGN     | DB          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                |              |
| DRAWN      | DB          |                                                                                                                                                                                                                                                                                         |              |
| CHECKED    | ML          | DRAWING NO.                                                                                                                                                                                                                                                                             | REV. A       |
| MFG. APPR. | JLM         | D5381                                                                                                                                                                                                                                                                                   | SHEET 1 OF 2 |
| APPROVED   | WM          | TITLE                                                                                                                                                                                                                                                                                   | SCALE        |
| DE APPR.   | DS          | WINDOW BUSHING/GROMMET                                                                                                                                                                                                                                                                  | NTS          |
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**D5381-3 GROMMET**



**SECTION B-B**



**NOTES:**

- 1) MATERIAL: URETHANE RUBBER, 80A DUROMETER, BLACK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: <0.01 lbs

**RELEASED**  
2016-06-08

APPROVED  
*ck*

|            |          |                                                                                                                                                                                                                                                                                          |              |
|------------|----------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | DB       | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                                |              |
| DRAWN      | DB       | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                              |              |
| CHECKED    | ML       | DRAWING NO.                                                                                                                                                                                                                                                                              | REV. A       |
| MFG. APPR. | JLM      | <b>D5381</b>                                                                                                                                                                                                                                                                             | SHEET 2 OF 2 |
| APPROVED   | WM       | TITLE                                                                                                                                                                                                                                                                                    | SCALE        |
| DE APPR.   | DS       | <b>WINDOW BUSHING/GROMMET</b>                                                                                                                                                                                                                                                            | NTS          |
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